

Date: Thursday, 5/4/2006 11:12:41 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MOUNTING BRACKET
Job Number	: 26941		
Estimate Number	: 11797		
P.O. Number	: NIA	Part Number	: D2524
This Issue	: 5/4/2006 S.O. No. : NIA	Drawing Number	: D2524 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: NIA Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: NIA	Material	: NIA
Written By	: <i>See comments below</i>	Due Date	: 5/20/2006
Checked & Approved By	: <i>SA 06.05.08</i>	Qty:	13
Comment	: Est. C 00.06.26 Removed P/O for powder coat EC	-12 Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0250X02500	6061-T6 Bar .25" x 2.5"
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Comment: Qty.: 0.7657 f(s)/Unit Total : 9.1879 f(s)
 6061-T6 Bar .25" x 2.5"
 Material: 6061-T6 Bar - 0.25" thick
 Batch: *M15427*

SA 06.05.17

(13)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks: *2.50"*
2.25" x 8.75"

SA 06.05.17

(2)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per folio D2524
 Tumble
 Deburr any rough edges after tumbling

SA 06.05.17

(3)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 06.05.17

(13)

5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

SA 06/05/17

(13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 26/05/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING BRACKET

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/05/23

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 06-05-23

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 577

06/05/24 (13)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

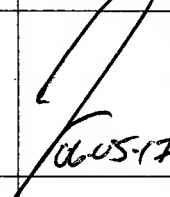
06/05/25 (13)

Job Completion



06-05-25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-05-17	6.0	Acid: Alodine as per QSI 005 4.1. SAD 06-05-21 (13) Add to estimate, permanent change	a.m	06-05-18	(13)		 06-05-17

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

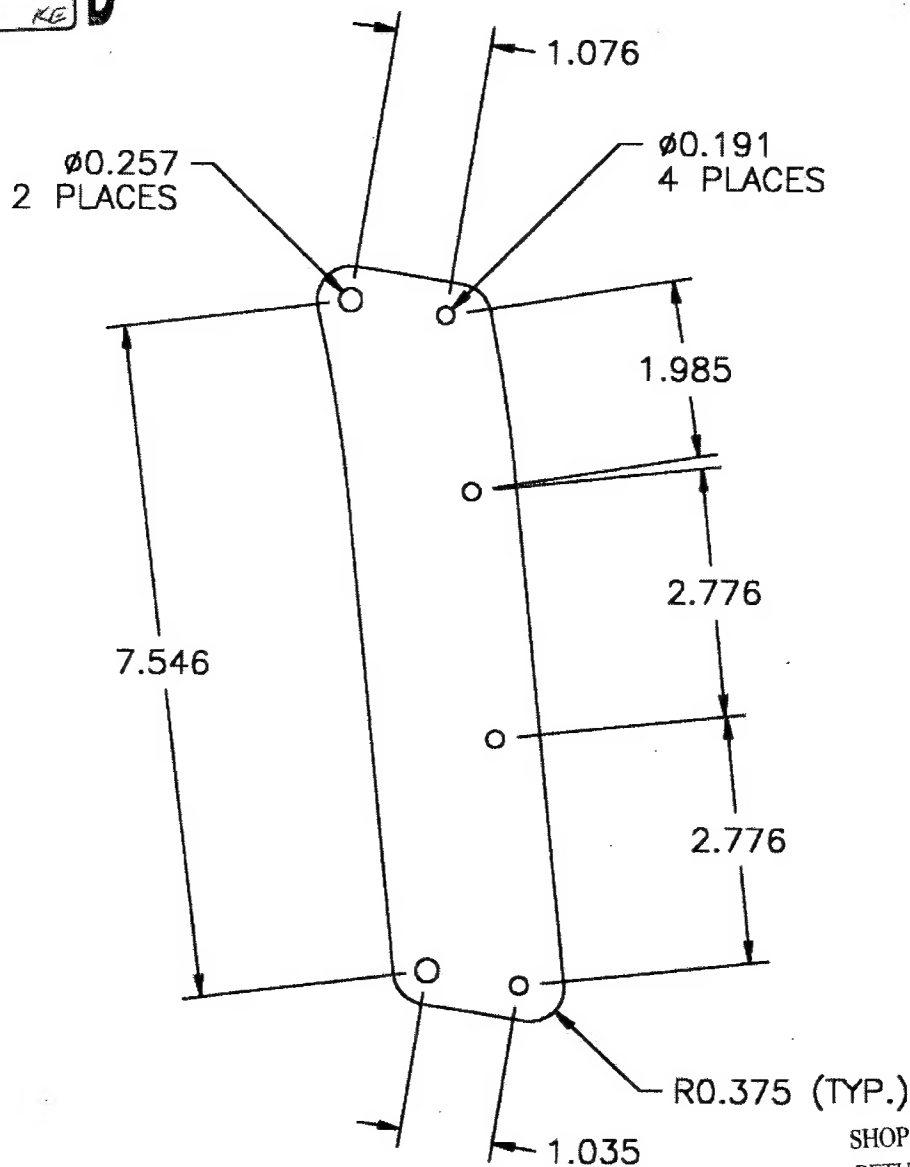
NOTE: Date & initial all entries

DART



DESIGN BY Bw	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED A	APPROVED A	DRAWING NO. D2524	REV. A SHEET 1 OF 1
DATE 95.12.20		TITLE SIDE PLATE	SCALE 1:2
A	95.12.20	NEW ISSUE	

RELEASED
97/07/15 KE
ECN001



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MATERIAL: 6061-T6 QQ-A-200/8 0.25 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE PER DART QSI 005 4.3

